Work Order Monday, April 25, 2		ſ				1		SERVICE AND ADDRESS OF THE SERVICE AND ADDRESS O	e said II - I -		Page 1
Revision ID:	3213-3 oor Panel			Accept					Setup Sta		
	25/2011 Start	Qty: 8.00 Qty: 8.00			Cust Iten Custome						
• •	rocess Plan:	H	Date: <u>//-04-3-5</u>	Tooling: SPC (Y/N):		Date:		I	Run Sta Sto		
Sequence ID/ Work Center ID	Operat Descri			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	r									
D3213	Rev A			•							
100 Waterjet	FLOW V	VATER JET		0.00				<u>R</u> 11-	6 -3		
FLOW CNC Waterjet		·								9	
	QC2- Ins	pect parts off n	nachine FAI/FAIB	0.00	÷			Ru-	5 <u>-3</u>		
QC Quality Control		Мето		0.00							

120 QC

Quality Control

QC8- Inspect parts - second check

Memo

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROC	EDURE CH	HANGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			***************************************						•	
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								,		
Part No		PAR #:	_ Fault Ca	tegory:	NCR:	Yes 1	10 DQ A	\:	Date:	
	R	esolution:	_ Disposit	ion:	QA: N	/C Clo	sed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORM	ANCE (NCR)				,
		Description of NC			tion B	Verification		ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
<i>y</i> *										
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Work	Order ID	68907
Monday,	April 25, 2011	10:52:50



Page 2

O AM Item ID: D3213-3 Accept Setup Start Revision ID: Door Panel Item Name: 4/25/2011 Start Qty: 8.00 **Start Date:** Cust Item ID: Required Date: 4/29/2011 Req'd Qty: 8.00 Customer: Reference: Run Start Date: Process Plan: Tooling: Date: Approvals: SPC (Y/N): Date: Date: Sequence ID/ Set Up/ Tool ID Tool # Plan Reject Operation Accept Work Center ID Qty Oty Description Code **Run Hours** 130 0.00 Small Fab 0.00 Small Fab Small Fab 140 Chemical Conversion Coat per QSI005 4.1 0.00 HandFinish 0.00 Memo Hand Finishing

150

Quality Control

Memo

QC3- Inspect Part Finish

=7 m-1 11/05/04



Stop



Stop

Insp.

Stamp

Reject

Number

Il W05/04

Dart	Aer	osp	ace	Ltd	
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action S	Verification	Approval	Approval		
DATE	STEP	Section A	Initial Action Descripti Chief Eng Chief Eng		n Sign & Date	Section C	Chief Eng	QC Inspect	
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Work	Order	ID	68907
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Monday, April 25, 2011 10:52:50 AM



Page 3

Item ID:

D3213-3

Accept

Setup Start

Stop



Revision ID:

Item Name:

**Start Date:** 

Required Date: 4/29/2011

Door Panel

4/25/2011

Start Qty: 8.00

Req'd Qty: 8.00



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:	
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Process Plan:

Date:

Tooling:

Date:

Tool # Plan

Code

Run

Start



OC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop



Sequence ID/

Work Center ID

160

Packaging

Description

Operation

Identify as per dwg & Stock Location 232.15

Memo

Memo

0.00

0.00

**Run Hours** 

Accept Qty

Reject Qty 1

Reject Insp. Number

Stamp

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

0.00

**Quality Control** 

W/O:			V	VORK ORDER CHANGE	S	•			· •
DATE S	STEP	PRO	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·	_				1	,	
Part No: _		PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ/	<b>A:</b>	Date:	
	Res	solution:	Disposit	ion:	QA: N/C CI	osed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMAN	ICE (NCF	R)			
DATE S	STEP	Description of NC		Section B Ve			Approval	Approval	
DATE	DIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
	r								
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		•							

# **Picklist Print**

Monday, April 25, 2011 10:52:59 AM

Work Order ID: 68907

D3213-3

Parent Item Name: Door Panel



Start Date: 4/25/2011

Required Date: 4/29/2011

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

Parent Item:

IPP Rev:A IPP Rev:B

New Issue

05-11-17 JLM

Now on Waterjet 07-02-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No		7 - AM - AMV N	100	sf	330.5700	0.4714	3.969684	4.5	,	
							,			ľ	B11-5-	3	

2024-T3 .063 sheet

Location .	Loc Qty	Loc Code		
MAT022	330.57		-	•
113867	1.19	•		•
117018	41.38		47019	
117392	288	•	117342	

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				•		,						
Part No		PAR #:	Fault Ca	tegory:	NCR:	Yes I	No DQA:		_ Date: _			
	Re	esolution:	Disposition:			I/C Clo	sed:		Date:			
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (	NCR	)			¥		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng		Sign & Section C			Approval Chief Eng	Approval QC Inspector		
			Office Ling	Office Ling		Dato						
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DART AEROSPACE LTD	Work Order:	48907
Description: Door Panel	Part Number:	D3213-3
Inspection Dwg: D3213 Rev: A	·	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

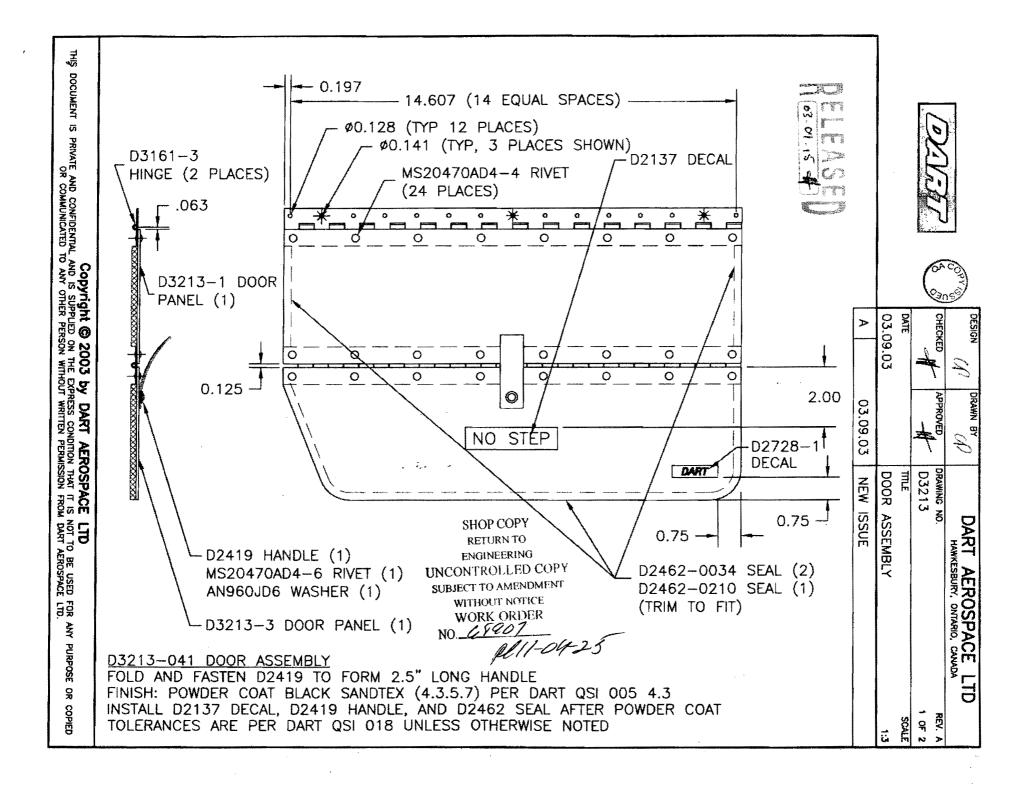
X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.00	+/-0.030	15,00	¥		T 1801	
0.300	+/-0.010	300	4		V (BO)	
14.400	+/-0.010	14,400	*		٦	
Ø0.128	+0.005/-0.001	.131	*		v .	
4.42	+/-0.030	4,427	*		J	
1.00	+/-0.030	,999	77		<b>V</b>	
0.300	+/-0.010	799	*		V	
Pitch 2.057	+/-0.005	3.000	*		V	
		-				4
					•	
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	•					
		W				

Measured by: R	Audited by:	Prototype Approval:	N/A
Date: (1-5-3	Date: (1/05/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
В	04.06.15	Tolerance changed for 14.400 dimension	KJ/JLM ,	
С	08.11.27	Diameter symbol added to dimension 0.128	KJ/EC	N

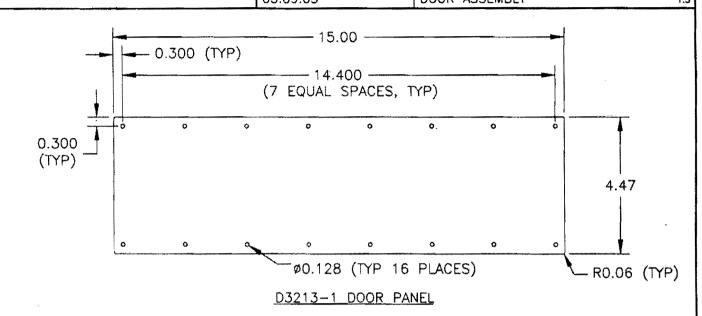
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DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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							<u> </u>						
Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Yes	No <b>DQ</b>	A:	Date:					
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DATE	STEP	Description of NC			ion B	Verific		Approval	Approval				
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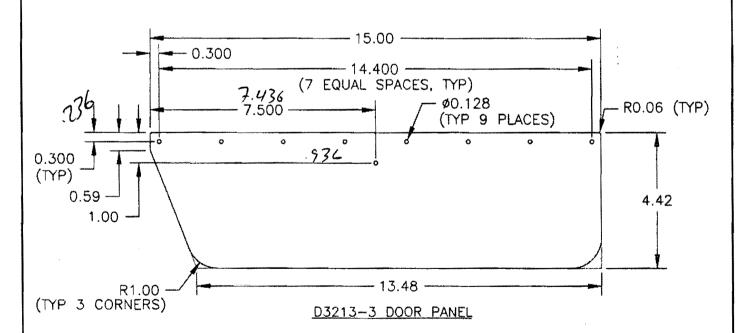


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NCR:		1	WORK ORD	ER NON-CONFORM	ANCE	(NCR)						
D.47E	OTED	Description of NC	Corrective Action Section B				Verification		Approval	Approval		
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			4/10 48701	
	DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
١	CHECKED M	APPROVED	DRAWING NO.	REV. A
1	d	ar	D3213	2 OF 2
	DATE	Jinhii/ide	TITLE	SCALE
	03.09.03		DOOR ASSEMBLY	1:3



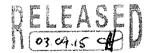


D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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W/O:		WORK ORDER CHANGES										
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Resolution:			Disposition: Q			N/C Clo	sed:	Date:				
NCR:	,		WORK ORD	ER NON-CONFORMA	ANCE	(NCR	)					
DATE	OTED	Description of NC	Corrective Action Section B			<u>-</u>	Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector			
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[.] NOTE: Date & initial all entries